

Slip 09/09

Date: Tuesday, 8/28/2007 3:17:28 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 34292	
Estimate Number : 10260	
P.O. Number : N/A	Part Number : D23623
This Issue : 8/28/2007 S.O. No. : N/A	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E1
Previous Run : 31503	Material : N/A
Written By : <u>JA 07.08.28</u>	Due Date : 9/7/2007 Qty: 6 Um: Each
Checked & Approved By : <u>JA 07.08.28</u>	
Comment : Est: G 80.05.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
Step Support
Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	79807

W 570829

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

ml 07/09/02

6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

ml 07/09/02

6

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 07/09/03

6

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

ml 07/09/02

6

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

M 105 068

BR

07-09-04

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:17:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 34292

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

mf 02-09-04

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B30971

mf 07-09-05

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B30972

mf 07-09-05

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch M102805

mf 07-09-05

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/05 (6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 481

CU 7/9/05

(6)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

En 07/09/05 (6)

Job Completion



u 07-09-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	#	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
		SCALE
		1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
35 BEFORE MANUFACTURE
OK 01/04/05

0.257 X 0.75 SLOT

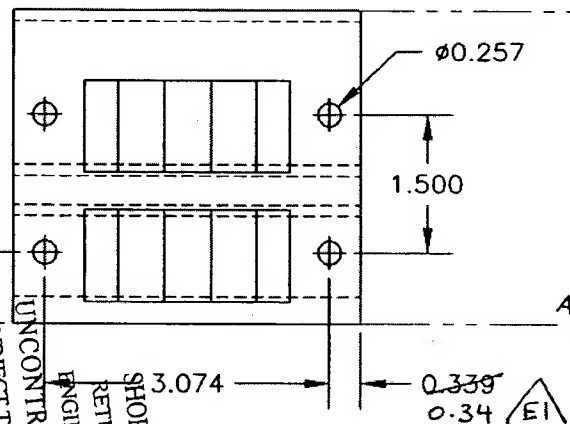
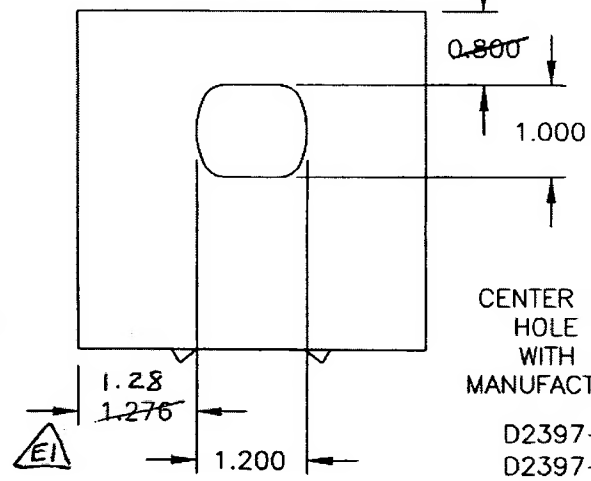
REMOVE TIPS
FROM CASTING
MAX 0.080

VIEW A-A

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

D2362-3



0.77 0.767
EI

NO 34292

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 34292

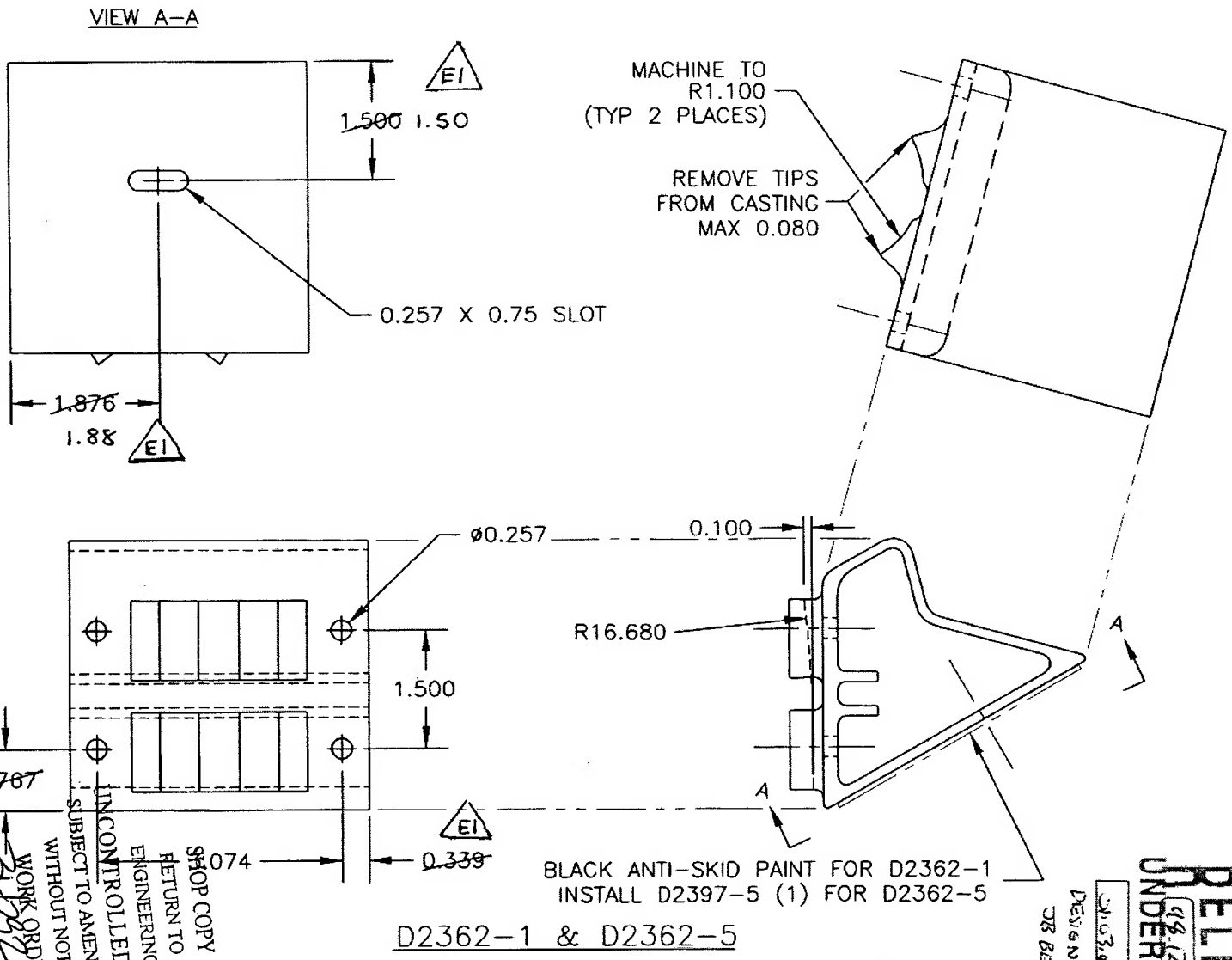
NOTES:
MAKE FROM D2362
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	DRAWING NO.	D2362	REV. E
TITLE	STEP SUPPORT BRACKET	SHEET 2 OF 3		SCALE
				1:2

RELEASED
98.12.14
UNDER REVIEW

DESIGN OK, BUT CHECK BY
OR BENCH MANUFACTURE
OK 98.1.05



NOTES:
MAKE FROM D2365
D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED [Signature]	REV. E
DATE 98.12.04	DRAWING NO. D2362	SHEET 3 OF 3
	TITLE STEP SUPPORT BRACKET	SCALE 1:2

UNDER REVIEW

31.03.15 CP

DESIGN OK BUT CHECK WITH
JTB BEFORE MANUFACTURE

RELEASED
98.12.14 KE

3.750 (REF)

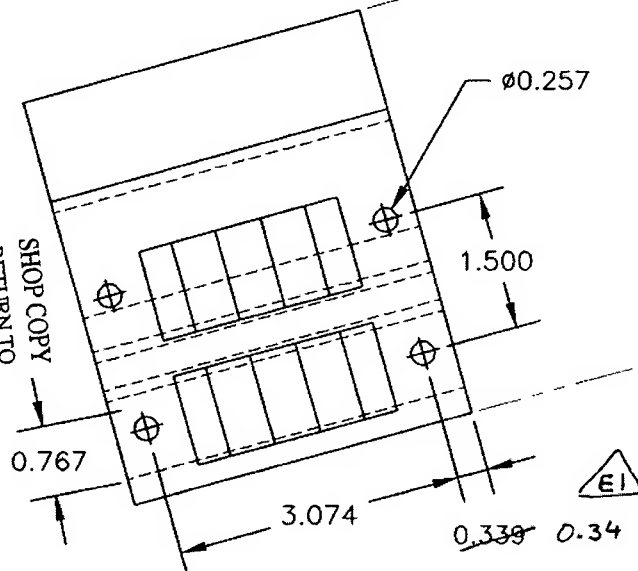
REMOVE TIPS
FROM CASTING
MAX 0.080

BLACK ANTI-SKID PAINT

D2244-3.75

WELD PER DART 1/8
QSI 004

D2362-7



D2362-041 (SHOWN)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

2404